

Date: Tuesday, 09/09/2008 10:43:31 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY EC 130
Job Number	: 41624B		
Estimate Number	: 10814		
P.O. Number	:	Part Number	: D3172041
This Issue	: 09/09/2008 S.O. No. :	Drawing Number	: D3172 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 09/09/2008 Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 41624B	Material	:
Written By	:	Due Date	: 19/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 08.9.09</u>		
Comment	: Est Rev:B 04.01.05 Added Step 5 inspection KJ/RF Est Rev:C 08-08-29 revC as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)



Pick:

Qty 4 D3166-1 Basket Hoop Batch: B41448

SAD

08/09/25

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 42.0000 f(s)/Unit Total : 42.0000 f(s)

Material: 304/316 SS 3/4" x 3/4" square tubing 0.065" wall

(M304TS0.750W.065)

Batch: 11108246

SAD

08/09/25

3.0	D2012117	Clevis
-----	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2012-117

Clevis

B31101

SAD

08/09/30

4.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-3

Hinge plate

B342075

SAD

08/09/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 10:43:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 41624B

Part Number: D3172041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B39560



JS 08/09/30

6.0	D31741	Mounting Lug
-----	--------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3174-1

Mounting Lug

B41269



JS 08/09/30

7.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B40895



JS 08/09/30

8.0	M304EX07516F	Expanded Metal Flat SS
-----	--------------	------------------------



Comment: Qty.: 48.0000 sf(s)/Unit Total : 48.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

48sf M304EX0.75-16F

Expanded Metal

M108830



JS 08/10/07

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Qty 4 D3166-1 as per Dwg D3172

2-Cut 3/4" x 3/4" square tubing as per Dwg D3172

3-Drill holes in D3172-3 as per Dwg D3172

JS 08/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 10:43:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 41624B

Part Number: D3172041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr & Remove all markings from material

5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Deburr as required

A/R SS Rod Batch M108775

SS 08/10/08

10.0

QC9

VISUAL WELDING INSPECTION



PC 08-10-07



Comment: VISUAL WELDING INSPECTION

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SS 08/10/07

12.0

POWDER COATING

POWDER COATING



M109152



(11)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005.4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*9:20
05
400
9:50*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*11:00
05
400
11:30*

M-L 08/10/08

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

SS 08/10/08

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 41624 PC 8/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 10:43:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 41624B

Part Number: D3172041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



NF 08-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

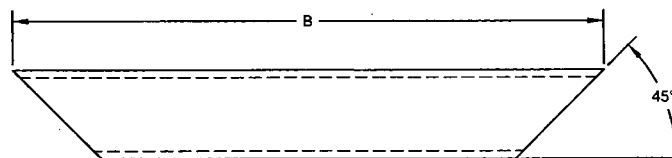
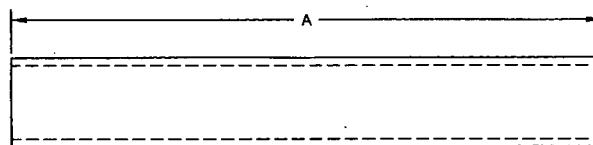
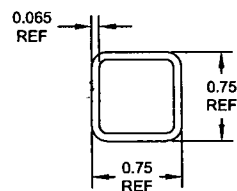
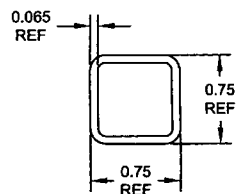
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



RELEASE
08-02-21/10

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03		
B	ADD D3172-9 & D2012-117	CP	03.01.07		
A	NEW ISSUE	OS	02.12.02		
REV.	DESCRIPTION	BY	DATE		
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED				DRAWING NO.	REV. C
MFG. APPR.				D3172	SHEET 1 OF 1
APPROVED				TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NT		
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NOTES:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065

2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F

3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

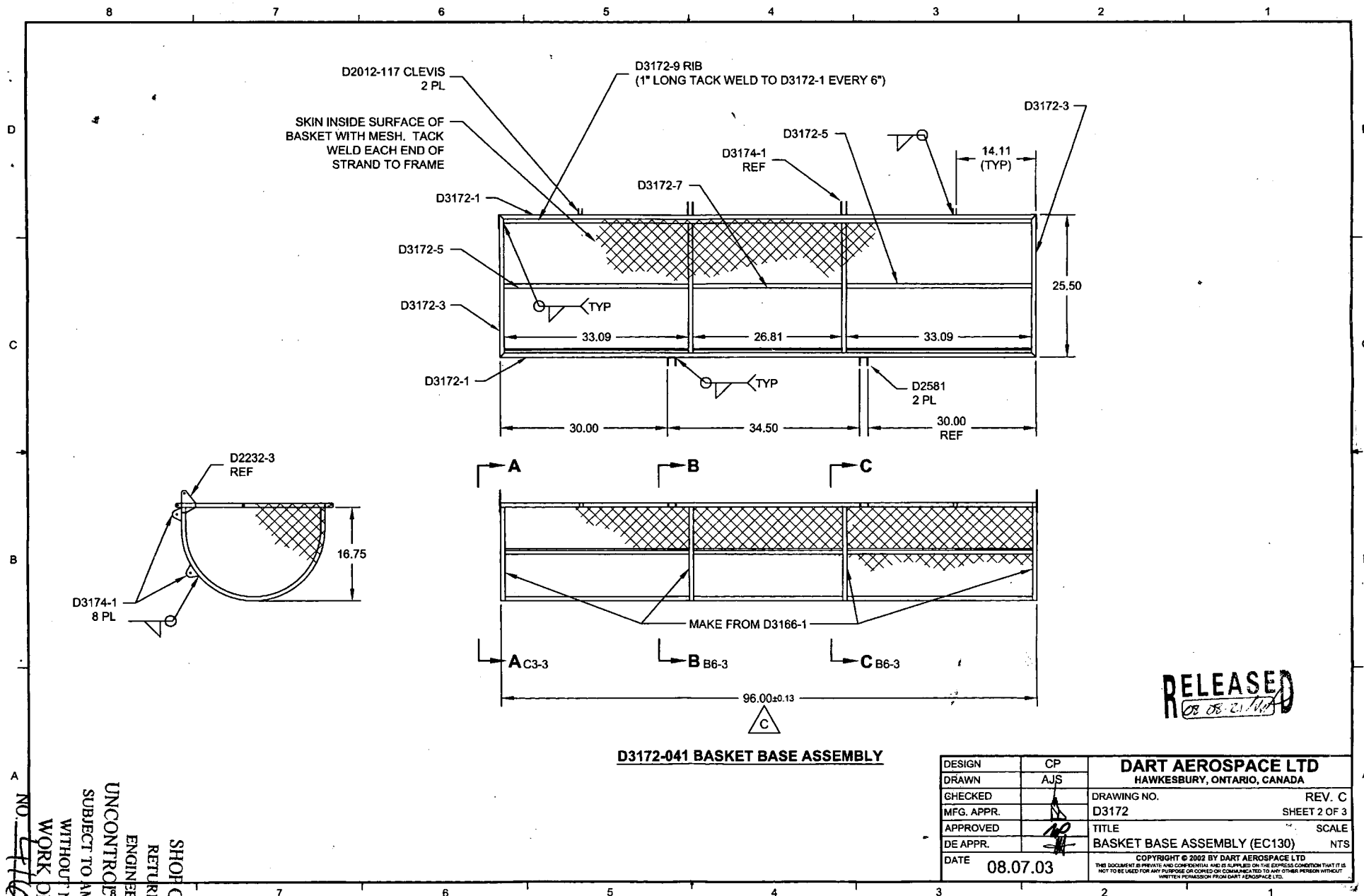
7) IDENTIFICATION: NONE

8) WEIGHT N/A

9) WELD PER DART CSI 004

SECRET

3) FINISH: POWDER COAT
4) TOLERANCES: PER
5) THICKNESS: INCHES UNL
6) BREAK SHARP EDG
7) IDENTIFICATION: N
8) WEIGHT: 5/16
9) WELD: PEWEE
10) FINISH: BATT
11) FINISH: BATT
12) FINISH: BATT
13) FINISH: BATT
14) FINISH: BATT
15) FINISH: BATT
16) FINISH: BATT
17) FINISH: BATT
18) FINISH: BATT
19) FINISH: BATT
20) FINISH: BATT
21) FINISH: BATT
22) FINISH: BATT
23) FINISH: BATT
24) FINISH: BATT
25) FINISH: BATT
26) FINISH: BATT
27) FINISH: BATT
28) FINISH: BATT
29) FINISH: BATT
30) FINISH: BATT
31) FINISH: BATT
32) FINISH: BATT
33) FINISH: BATT
34) FINISH: BATT
35) FINISH: BATT
36) FINISH: BATT
37) FINISH: BATT
38) FINISH: BATT
39) FINISH: BATT
40) FINISH: BATT
41) FINISH: BATT
42) FINISH: BATT
43) FINISH: BATT
44) FINISH: BATT
45) FINISH: BATT
46) FINISH: BATT
47) FINISH: BATT
48) FINISH: BATT
49) FINISH: BATT
50) FINISH: BATT
51) FINISH: BATT
52) FINISH: BATT
53) FINISH: BATT
54) FINISH: BATT
55) FINISH: BATT
56) FINISH: BATT
57) FINISH: BATT
58) FINISH: BATT
59) FINISH: BATT
60) FINISH: BATT
61) FINISH: BATT
62) FINISH: BATT
63) FINISH: BATT
64) FINISH: BATT
65) FINISH: BATT
66) FINISH: BATT
67) FINISH: BATT
68) FINISH: BATT
69) FINISH: BATT
70) FINISH: BATT
71) FINISH: BATT
72) FINISH: BATT
73) FINISH: BATT
74) FINISH: BATT
75) FINISH: BATT
76) FINISH: BATT
77) FINISH: BATT
78) FINISH: BATT
79) FINISH: BATT
80) FINISH: BATT
81) FINISH: BATT
82) FINISH: BATT
83) FINISH: BATT
84) FINISH: BATT
85) FINISH: BATT
86) FINISH: BATT
87) FINISH: BATT
88) FINISH: BATT
89) FINISH: BATT
90) FINISH: BATT
91) FINISH: BATT
92) FINISH: BATT
93) FINISH: BATT
94) FINISH: BATT
95) FINISH: BATT
96) FINISH: BATT
97) FINISH: BATT
98) FINISH: BATT
99) FINISH: BATT
100) FINISH: BATT



RELEASED

SHOF COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 41002413

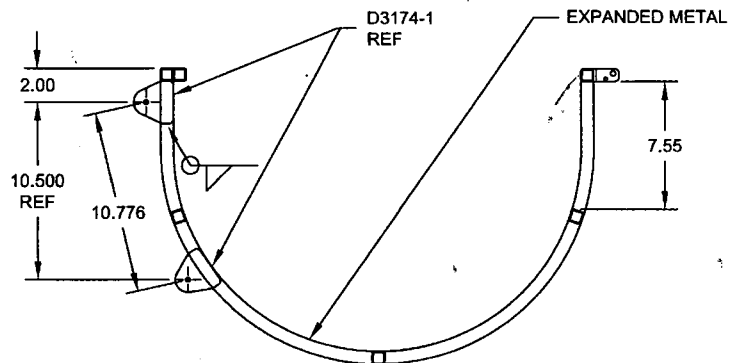
8 7 6 5 4 3 2 1

D

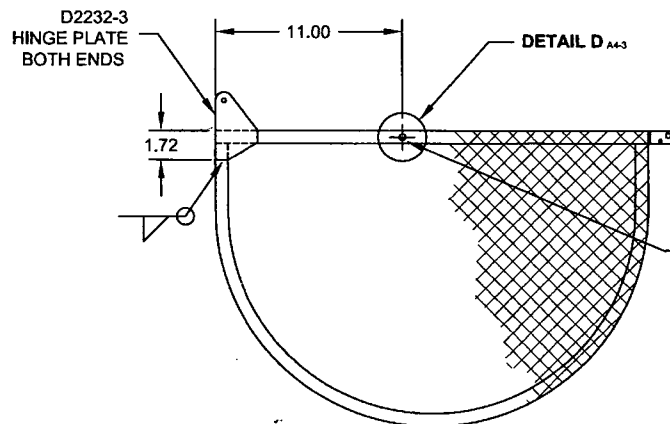
C

B

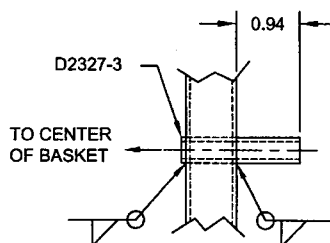
A



**SECTION B-B_{B5-2}
AND SECTION C-C_{B3-2}**
RIB DETAIL
SCALE 2X






SECTION A-A_{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D_{D3-3}
SCALE 4X

RELEASED
08.08.21/1140

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NO. 11402913
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

7 6 5 4 3 2 1

